



**Insert Carbide 2+2 Spoilboard Surfacing, Rabbeting,
Flycutter, Slab Leveler & Surface Planer Router Bits**
(Max Cutting Depth Per Pass 1/4")

Tool No.	Plywood/Chipboard	Hardwood	MDF	Softwood	Plastic
	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth	RPM* / IPM** / Chip Load Per Tooth
RC-2251	18,000 / 130" / 0.0038"	18,000 / 110" / 0.0031"	18,000 / 220" / 0.0062"	18,000 / 270" / 0.0075"	18,000 / 120" / 0.0031"
RC-2351	18,000 / 130" / 0.0038"	18,000 / 110" / 0.0031"	18,000 / 220" / 0.0062"	18,000 / 270" / 0.0075"	18,000 / 120" / 0.0031"
RC-2252	14,300 / 100" / 0.0037"	14,300 / 100" / 0.0037"	14,300 / 180" / 0.0062"	14,300 / 210" / 0.0075"	14,300 / 100" / 0.0050"

*RPM: Revolutions Per Minute

**IPM: Inches Per Minute

Simple Machining Calculations:

To find **RPM**: $(\text{SFM} \times 3.82) / \text{diameter of tool}$

To find **SFM**: $0.262 \times \text{diameter of tool} \times \text{RPM}$

To find **Feed Rate IPM**: $\text{RPM} \times \# \text{ of flutes} \times \text{chip load}$

To find **Chip Load**: $\text{Feed Rate IPM} / (\text{RPM} \times \# \text{ of flutes})$

To find **Ramp Down**: $\text{Feed Rate IPM} / \# \text{ of flutes}$

Disclaimer: It is important to understand that these values are only recommendations.

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